

Work Order ID 101140

May-01-13 3:26:13 PM

\*101140\*

Page: 1

Item ID: D2596

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Web. 205 Skidtube

Start Date: 5/01/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: *13-05-01* Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2596	Rev D								
100		0.00							
<b>*100*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*110*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

⑧ *SAD 13-05-02*

⑧ *SAD 13-05-02*

⑧ *Ø 13-05-03*



# Work Order ID 101140

May-01-13 3:26:13 PM

\*101140\*

Page 2

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Approvals: Process Plan: Date:

Tooling: Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
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\*130\*

Packaging

Memo

0.00

Packaging

③

SAD 13-05-03

140	QC21- Final Inspection - Work Order Release	0.00							
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\*140\*

QC

Memo

0.00

Quality Control

13/5/14

13-05-3

# Picklist Print

May-01-13 3:26:17 PM

Page 1

Work Order ID: 401140

\*101140\*

Parent Item: D2596

\*D2596\*

Parent Item Name: Web. 205 Skidtube

Start Date: 5/01/13

Required Date: 5/10/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: D99.02.02Changed QA to QC. Added Step 6 and CostDM  
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	175.0000	1	8			

\*D2500-3-100\*

Ext'n - I' Beam Web 4"

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SAD 13-05-02

Location

Loc Qty

Loc Code

LG

175

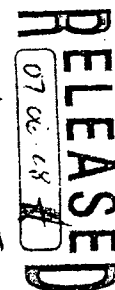
84873

4

89110

171

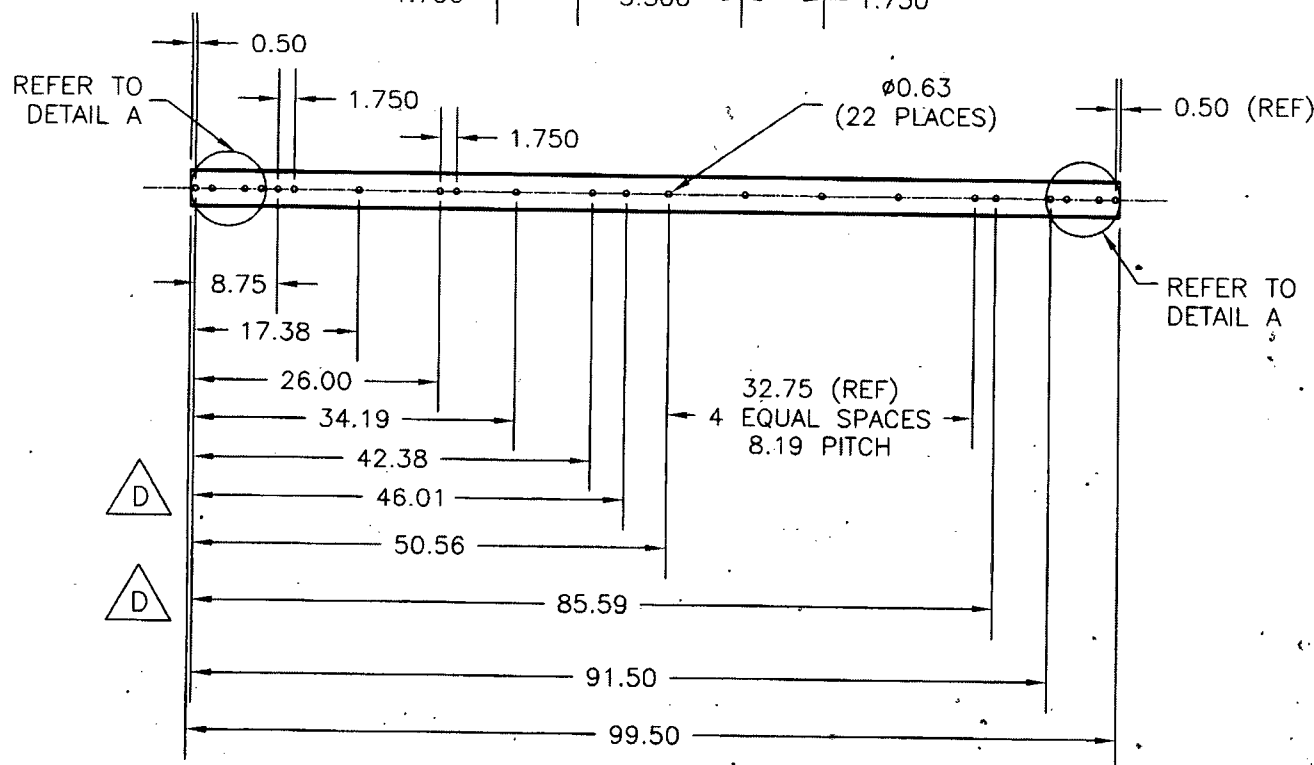
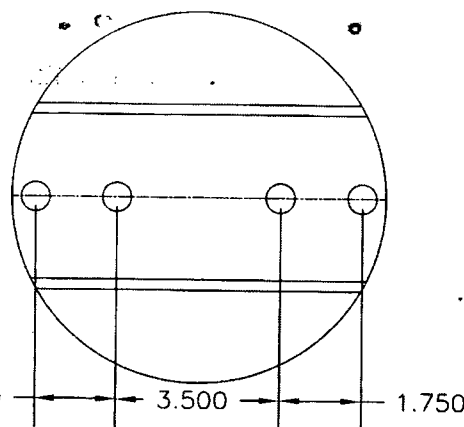
8



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WITHOUT NOTICE  
WORK ORDER  
NO. 10-140 M



8. MLS  
13-05-0

**DETAIL A**  
SCALE 1:4



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN		DRAWING NO.		REV. D	
04		04		SHEET 1 OF 1	
CHECKED	APPROVED	DRAWING NO.			
		D2596			
DATE		TITLE			
07.04.17		205 WEB			
A	96.09.16	NEW ISSUE			
B	97.07.23	Ø0.63 HOLE WAS Ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

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